

Work Order ID 53176

October 26, 2009 9:03:47 AM



Page 1

Item ID: D3173-041
Revision ID: B
Item Name: Beam Assembly

Accept



Setup Start



Stop



Start Date: 09/10/2009 Start Qty: 4.00
Required Date: 10/11/2009 Req'd Qty: 4.00



Cust Item ID:
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: RL Date: 09-10-24 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	BAND SAW	0.00							
	Bandsaw	0.00							
Jeaspa Bandsaw	Memo Cut blank: 56" long <input type="checkbox"/> Machine holes as per Folio FA295 and Dwg D3173 <input type="checkbox"/> Identify as D3173-1								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1	0.00							
HAAS CNC vertical machine #1	Memo Machine holes as per Folio FA295 and Dwg D3173 Identify as D3173-1								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	Memo								

4 0

4 0

4 0

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Item ID: D3173-041
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Setup Start



Stop



Start Date: 26/10/2009 Start Qty: 4.00
Required Date: 10/11/2009 Req Qty: 4.00



Cust Item ID:
Customer:

Reference:

Run / Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Handwritten: 09/11/24

Handwritten: (X4)

Handwritten: 0

Hand Finishing

170

QC - Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Handwritten: 09/11/24

Handwritten: (X4)

Handwritten: 0

Quality Control

Handwritten: Perm. Chang

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Handwritten: 09/11/24

Handwritten: X4

Handwritten: 0

Powder Coating

Ensure Nut Plate thread is covered. 100pm START TIME:
3209 OVEN TEMPERATURE: 139 FINISH
TIME: ..

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Setup Start



Stop



Start Date: 26/10/2009 Start Qty: 4.00
Required Date: 10/11/2009 Req'd Qty: 4.00



Cust Item ID:
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00



09-11-24

14

QC

Memo

0.00

Quality Control

200

Small Fab

0.00



0.00

Small Fab

Memo

Assemble per Dwg D3173. □ Install Mounting Lug as per Dwg D3173. D3175-041 is included in K10017 BOM.

09/11/30 4

210

QC5- Inspect part completeness to step on W/O

0.00



0.00

QC

Memo

2) 08/11/30

14

Quality Control

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Item ID: D3173-041
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Accept



Setup Start



Stop



Start Date: 26/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 4.00



Customer:

Reference:



Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 	Identify as per dwg & Stock Location <u>518</u>	0.00							
Packaging	Memo	0.00							
Packaging									
230 	QC21 - Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

9/6/30 (4) 9

09/11/30 9

pl 09-11-30
(4)

Picklist Print

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Page 1

Work Order ID: 53176

Parent Item: D3173-041RevB

Parent Item Name: Beam Assembly


Start Date: 26/10/2009

Required Date: 10/11/2009

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L5		Purchased	No			100	Each	1,077.000	8.0000			
												
Nut												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1077

110382

10

111127

4

111636

63

112314

1000

D3178-041RevA

Manufactured

No

170

Each

18.0000

8.0000



Nut Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

24895

10

25298

8

8/509/11/30

8/509/11/30

2
6

Picklist Print

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Work Order ID: 53176

Parent Item: D3173-041RevB

Parent Item Name: Beam Assembly

Start Date: 26/10/2009

Required Date: 10/11/2009

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6TR4.0X2.0W1 25		Purchased	No			170	f	6.1600	19.7368			



6061-T6 Rect Tube 4.0 x 2.0 x .125w

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

6.16

109025

0.31

109088

0.36

14394

4.66

19265

0.83

112830

200

Each

2,249.000 32.0000

AN3-5A

Purchased

No



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2249

100188

188

105057

2061

19.6875

Eff 09/10/30

32

Picklist Print

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Work Order ID: 53176



Parent Item: D3173-041RevB



Parent Item Name: Beam Assembly

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN5-23A Bolt		Purchased	No			200	Each	23.0000	8.0000		<i>Ep 09/11/30</i>	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

23

19278

23

200

Each

1,897.000 32.0000

8

AN960JD10

Purchased

No



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1897

105442

95

109059

2

109840

23

110985

202

111279

5

111658

64

112314

1000

112369

506

*"oops my bad"
all good*

32

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Shop Packet Print

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Picklist Print

Page 4

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Work Order ID: 53176

Parent Item: D3173-041RevB

Parent Item Name: Beam Assembly


Comments:

Start Date: 26/10/2009

Required Date: 10/11/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516  Washer		Purchased	No			200	Each	1,595.000	16.0000		<i>9/30/14/30</i>	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1595

100564
106167
107584
107959
108246
108672
109059
109752
110363
110523
111279
112082
112314
112794
112828

2
6
34
43
46
2
49
22
46
57
39
68
500
181
500

"oops my bad"
all good

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Shop Packet Print

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Picklist Print

Page 5

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Work Order ID: 53176



Parent Item: D3173-041RevB



Parent Item Name: Beam Assembly

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg. Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3175-041RevA Manufactured

No

200

Each

6.0000

8.0000



Mounting Lug

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

25025

1

41678

5

MS20601-AD4W4

Purchased

No

200

Each

47.0000

32.0000



Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

47

19278

47

9/30/11/30
B53458

9/30/11/30

21
M113068

October 26, 2009 9:03:52 AM

Shop Packet Print

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3173	REV. B SHEET 1 OF 3
DATE 03.01.07		TITLE BEAM ASSEMBLY	SCALE NTS
A	02.12.03	NEW ISSUE	
B	03.01.07	REMOVE PIP PINS	

PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3173-041	BEAM ASSEMBLY
1	D3173-1	BEAM
2	D3175-041	MOUNTING LUG
2	D3178-041	NUT PLATE
8	AN960JD10	WASHER
4	AN960JD516	WASHER
2	MS21042L5	NUT
8	MS20601AD4W4	RIVET
8	AN3-5A	BOLT
2	AN5-23A	BOLT

NOTES

D3173-1 BEAM:

- 1) PART IS SYMMETRICAL ABOUT CENTERLINE
- 2) MATERIAL: 6061-T6 RECTANGULAR TUBING, 4" x 2" x 0.125" WALL (QQ-A-200/8)
(REF DART SPEC. M6061T6TR4.0x2.0W125)
- 3) BREAK ALL SHARP EDGES 0.010-0.020
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 OUTSIDE ONLY
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
NO. 53174

BS 09-10-26

RELEASED
03.01.20

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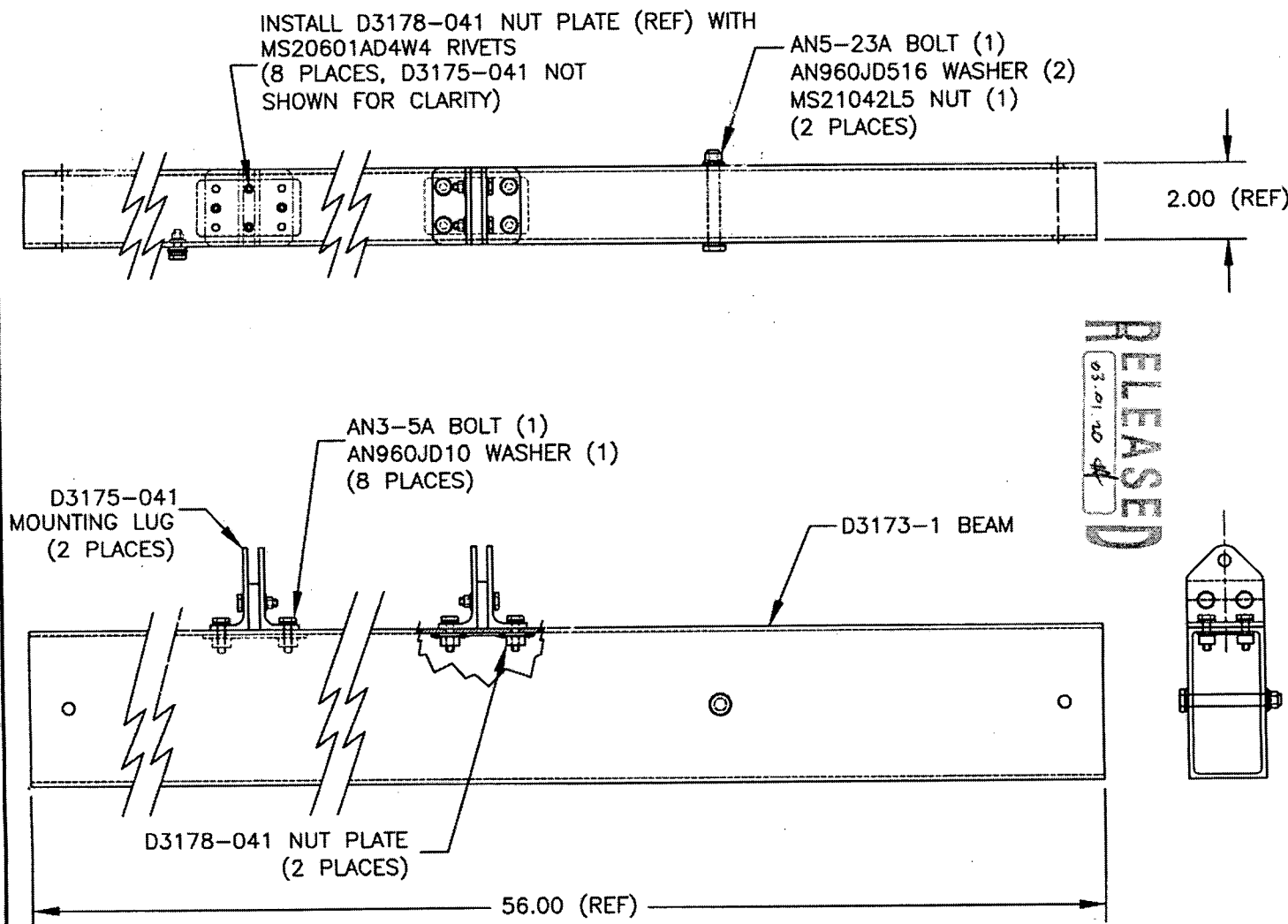
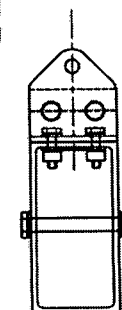
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CHECKED	APPROVED	DRAWING NO.	REV. B
03.01.07		D3173	SHEET 2 OF 3
DATE	TITLE	SCALE	
	BEAM ASSEMBLY	1:4	

RELEASED
03.01.10



D3173-041 BEAM ASSEMBLY

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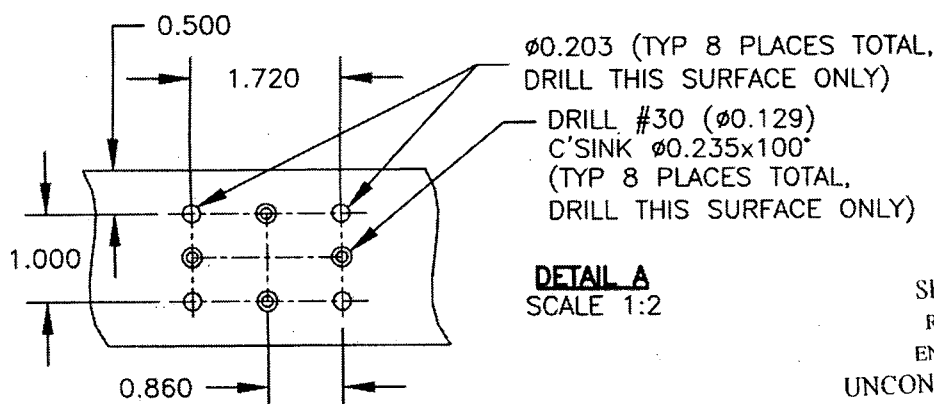
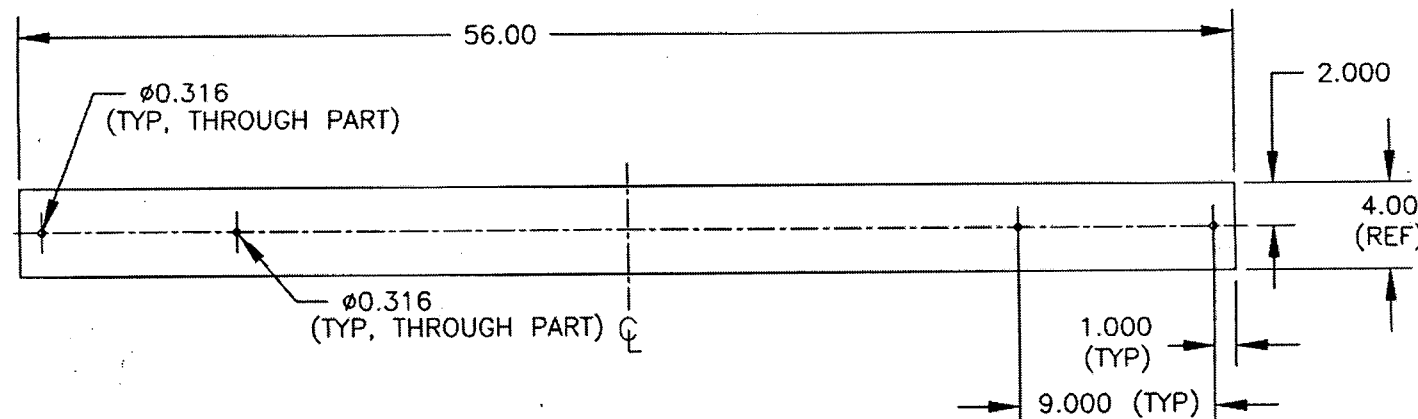
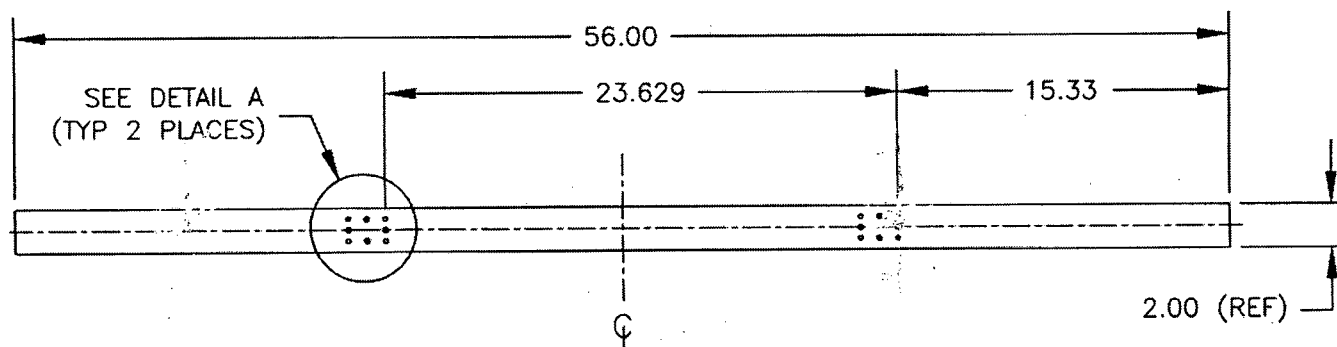
NO. 53176

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DESIGN	DRAWN BY	DART AEROSPACE LTD
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DATE	DRAWING NO.	REV. B
03.01.07	D3173	SHEET 3 OF 3
	TITLE	SCALE
	BEAM ASSEMBLY	1:8

D3173-1 BEAM



DETAIL A
SCALE 1:2

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